

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77192

77192

Page 2

November-28-11 2:22:51 PM

Item ID: DSK076 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2891-1 TURNING DETAIL
 Start Date: 28/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: MAT 60								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/13
 R12-0213
 @

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NOTE: Date & initial all entries

Picklist Print

November-28-11 2:22:57 PM

Page 1

Work Order ID: 77192

77192

Parent Item: DSK076

DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003

Manufactured No

Each 9.0000

10

D6104-003

**

52 12/2/9

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

9

60943

3

66960

1

72807

5

77628

10

W/O:		WORK ORDER CHANGES					
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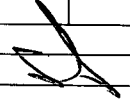
NOTE: Date & initial all entries

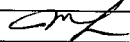
DART AEROSPACE LTD		Work Order: 77192
Description: Turning Detail for D2891-1		Part Number: DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.274	2.279	2.275	2.279	2.279
B	3.702	3.722		3.720	3.717	3.717	3.717	3.716
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.974	2.975	2.975	2.975	2.975
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.097	.098	.098	.098	.098
L								
M								
N								
O								
P								

Measured by:  Date: 12/21/7

Audited by:  Date: 12/22/11

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

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DART AEROSPACE LTD		Work Order:	77192
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
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Lathe Section								
A	2.274	2.279		2.279	2.279	2.281	2.289	2.289
B	3.702	3.722		3.710	3.713	3.715	3.714	3.715
C	2.564	2.584		2.574	2.574	2.574	2.574	2.574
D	0.718	0.738		.728	.726	.728	.728	.728
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.975	2.975	2.975	2.975	2.975
I	0.913	0.933		.920	.920	.920	.920	.920
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.098	.098	.098	.098	.098
L								
M								
N								
O								
P								

Measured by:	<i>[Signature]</i>	Date:	12/2/19
Audited by:	<i>[Signature]</i>	Date:	12/02/11
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>



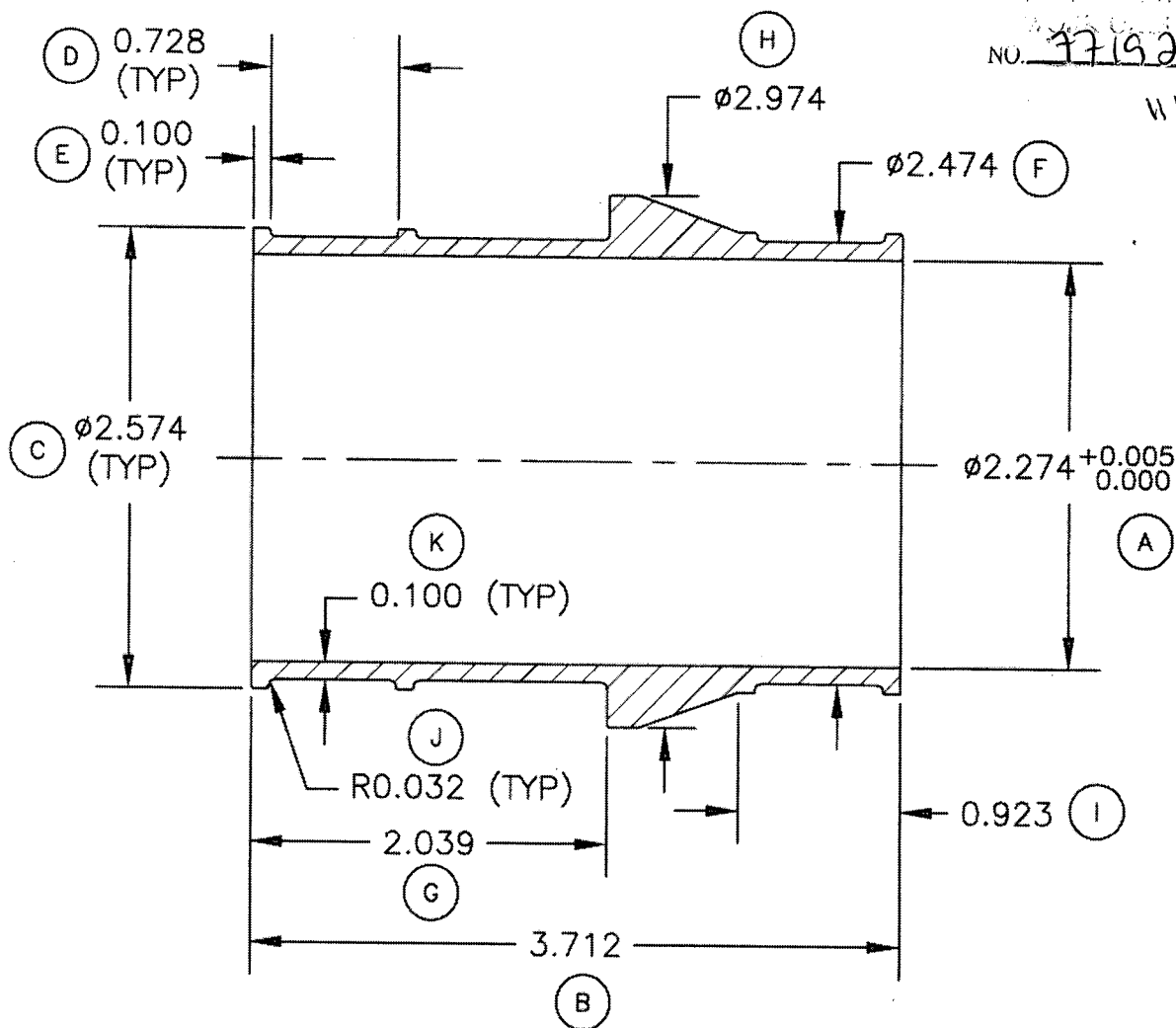
DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 H

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL

NO. 77192 H.C.J.

WJN/28



D2891-1 TURNING DETAIL

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